

Date: Wednesday, 12/7/2005 8:29:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE BRACKET HI-SLOPE
Job Number : 25142	
Estimate Number : 11004	
P.O. Number : N/A	Part Number : D2606
This Issue : 12/7/2005 S.O. No. : N/A	Drawing Number : D2606 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/7/2005 Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/10/2006
Checked & Approved By : SEE COMMENT BELOW	Qty: 19/20 Um: Each
Comment : Est. D 98.11.26 Added Inspection DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1582 sf(s)/Unit Total: 3.1647 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 Stack of 10
 (M2024T3S.040) Batch M19057

En 05/12/16 20

2.0	SHEAR	SHEAR
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Comment: SHEAR 9.0000" x 2.5000" (+/- 0.030)
 Cut Blank per template DT8247

En 05/12/16 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2606

En 05/12/16 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 05/12/16 20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SL 05-12-16 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 05/12/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/16	#30	one stack scrap (10 parts) was in clamps.	<i>[Signature]</i>	Scrap and Destroy and Reptke.	Ep 05/12/16	<i>[Signature]</i> 05-12-16	<i>[Signature]</i>	<i>[Signature]</i> 05-12-16

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2606

SB 06/01/16 20

SAD 1/12/05 20

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06.01.19 RE-ALODINE 20

SAD 12/12/05 20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06.01.20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48

06/1/27

(19)

ml 06/01/27 (19)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAD 06/01/30

(19)

SD 06/01/30

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25142
Description: Console Bracket		Part Number:	D2606
Inspection Dwg: D2606 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.841	+/-0.005	0.841	✓			
1.589	+/-0.005	1.594	✓			
0.621	+/-0.010	0.624	✓			
1.809	+/-0.010	1.806	✓			
2.430	+/-0.010	2.440	✓			
0.621	+/-0.010	0.625	✓			
8.309	+/-0.010	8.314	✓			
8.930	+/-0.010	8.939	✓			
8.710	+/-0.010	8.714	✓			
R0.250	+/-0.010	0.252	✓			
R0.156	+/-0.010	0.156	✓			
Ø0.098	+0.005/-0.000	0.098	✓			
0.040	+/-0.005	0.039	✓			mat. thickness

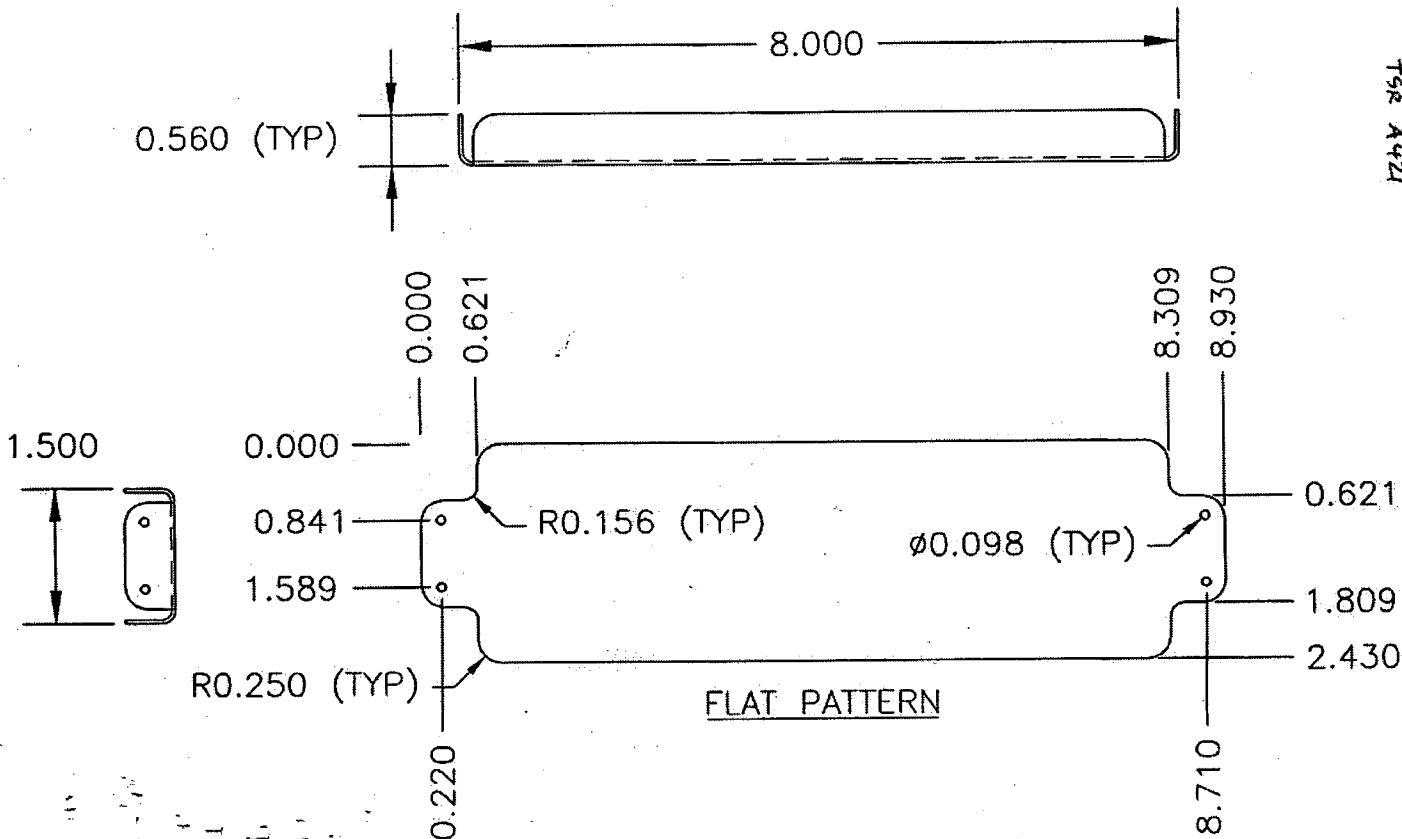
Measured by:	<i>En</i>	Audited by:	<i>J.J</i>	Prototype Approval:	N/A
Date:	05/12/16	Date:	05.12.16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	



RELEASED
97.11.04 KE
TSR 4421

DESIGN	DRAWN BY	DART AEROSPACE LTD
97.10.23	BW	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
KE		D2606
DATE	TITLE	SCALE
97.10.23	CONSOLE BRACKET	1:2
A	97.10.23	D2606 WAS D206-547-27
AI	02.06.04	ADD FINISH



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2606
BEND RADIUS 0.093

FINISH: CHEMICAL CONVERSION COAT PER DART Q51 005 4.1